



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 184820



Part No: D205-634-041

Job Qty: 1 ea

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD verf:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/9/18		0.00	0.00	Start Up Skidtubes		<i>mba</i>
110	CNC Bend Skidtubes	1 pcs	11/9/18		0.00	0.65	CNC Bend Skidtube		<i>max DP</i>
120	Skidtubes	1 pcs	11/9/18		0.00	2.89	Skidtubes-2		<i>DD</i>
130	QC	1 pcs	11/9/18		0.00	0.00	QC5		<i>BE</i>
140	Skidtubes	1 pcs	11/9/18		0.00	2.89	Skidtubes-2		<i>BE, DD</i>
150	QC	1 pcs	11/9/18		0.00	0.00	QC10		<i>38 DAS</i>
160	QC	1 pcs	11/9/18		0.00	0.00	QC5		<i>9-89 38</i>
170	HandFinish	1 pcs	11/9/18		0.00	1.31	HandFinish1		<i>D.R. 18/10/31</i>
180	Powdercoat	1 pcs	11/9/18		0.00	0.34	Powdercoat1		<i>BL 18-11-01</i>
190	QC	1 pcs	11/9/18		0.00	0.00	QC3		<i>11 12-11-02</i>
200	HandFinish	1 pcs	11/9/18		0.00	1.31	HandFinish4		<i>BE 18-11-03</i>
210	QC	1 pcs	11/9/18		0.00	0.00	QC5	DAS 69	<i>NOV 05 2018 68</i>
220	Packaging	1 pcs	11/9/18		0.00	0.00	Packaging3-1	9-89	<i>DAS 9-89 NOV 06 2018</i>
225	DC	1 pcs	11/9/18		0.00	0.00	DC		<i>21 9-89</i>
230	QC21-FG	1 Ea	11/9/18		0.00	0.00	QC21		<i>NOV 06 2018</i>

Part Op 110 - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe batch# in Descriptions: aft end of tube

120 - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

140 - 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimention. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web.Deburr 5-Drill pilot holes for aft cap using DT 8215Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640"and Deburr

170 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - START TIME: *8:10* OVEN TEMPERATURE: *320°* FINISH TIME: *8:40*

200 - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 *1188943* Sikaflex expire date: *19/03* 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 *1188943* Sikaflex expire date: *19/03*

5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: *5098120*

210 - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																													
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1210 Aderdeen Street Newmarket, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S120115 Part: D205-634-041 Job No. 181020 Serial Match: S120115 Revised: Inspect: Exp Date: Instructions: TO STL SH96-88 Issue 2, FA 287C SR00563NY 08/08/11, EASA S																																																					
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 Ea (1 ea)	90-Start up Operation	5114055
D2576-3	Step (Machining Detail)	1 Ea (1 ea)	140-Skiddtubes	5089827
D4202-1	Spacer	20 20 Ea (20 ea)	140-Skiddtubes	5094431
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-HandFinish	5084123
AN3-5A	Bolt	2 Ea (2 ea)	200-HandFinish	5084123 5085480
AN3C4A	Bolt	50 Ea (50 ea)	200-HandFinish	5095480 5095223
D2594-1	Plug	16 Ea (16 ea)	200-HandFinish	5120401
D2594-3	O-Ring	16 Ea (16 ea)	200-HandFinish	4x5084102 13x5106795
D2855	Cap	1 Ea (1 ea)	200-HandFinish	5066088
D3564-11	Wearplate Aft	1 Ea (1 ea)	200-HandFinish	5089788
D3564-13	Wearpad Fwd	1 Ea (1 ea)	200-HandFinish	5104115
D3564-5	Wearplate Center	1 Ea (1 ea)	200-HandFinish	5107249
D3564-9	Wearplate Fwd	1 Ea (1 ea)	200-HandFinish	5107312
NAS1149C0332R	Washer	50 Ea (50 ea)	200-HandFinish	5089465
NAS1149D0332J	Washer	2 Ea (2 ea)	200-HandFinish	5100407-1

M.U. 006262

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2580-1	1	4	0
140-Skiddtubes	D2576-3	1	43	0
	D4202-1	20	157	0
200-HandFinish	ALS7-1032-130	50	1,867	0
	AN3-5A	2	266	0
	AN3C4A	50	2,094	0
	D2594-1	16	40	0
	D2594-3	16	552	0
	D2855	1	45	0
	D3564-11	1	23	0
	D3564-13	1	19	0
	D3564-5	1	14	0
	D3564-9	1	13	0
	NAS1149C0332R	50	3,734	0
	NAS1149D0332J	2	2,171	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

ITEM	QTY -041	QTY -045	QTY -047	QTY -049	PART NUMBER	DESCRIPTION
1	X				D2580-041	SKIDTUBE ASSEMBLY
2		X			D2580-045	SKIDTUBE ASSEMBLY
3			X		D2580-047	SKIDTUBE ASSEMBLY
4				X	D2580-049	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2500-1-190	EXTRUSION
21			16	16	D2570	BUSHING
22	1	1	1	1	D2579-3	STEP
23		4			D2579	SPACER
24	16	16	8	8	D2594-1	PLUG
25	16	16	8	8	D2594-3	O-RING
26	1	1	1	1	D2596	205 WEB
27	1	1	1	1	D2855	AFT CAP
28	1	1			D3564-5	WEARSHOE
29	1	1			D3564-9	WEARSHOE
30	1	1			D3564-11	WEARSHOE
31	1	1			D3564-13	WEARSHOE
32	20	20	24	24	D4202-1	SPACER
33			1		D4406-041	WEARPLATE ASSEMBLY
34			1		D4406-043	WEARPLATE ASSEMBLY
35				1	D5061-1	FWD WEARPLATE
36				1	D5061-3	AFT WEARPLATE
50	50	50			ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
51	50	50			AN3C4A	BOLT
52	2	2	2	2	AN3-5A	BOLT
53			8	8	AN4-45A	BOLT
54	50	50			NAS1149C0332R	WASHER (AN980C10L)
55	2	2	2	2	NAS1149D0332J	WASHER (AN980JD10L)
56			8	8	MS21042-4	NUT (OR MS21042L4)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT (-041/-047/-049) GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
POWDER COAT (-045) GREEN SANDTEX (REF 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D2580-041 = 33.7 lbs
D2580-045 = 33.7 lbs
D2580-047 = 45.1 lbs
D2580-049 = 32.0 lbs
- 8) WELDING PER DART QSI 004.
- 9) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 10) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 11) USE DART DRILL TEMPLATE DT8217 & DT8937 ONLY FOR D2580-041/-045 TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTIONS B-B AND F-F (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS WITH SIKAFLEX-241-291.
- 12) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES FOR D2580-041/-045 AND 8 PLACES FOR D2580-047/-049)
- 13) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 184820 MJS
1870-17

RELEASED

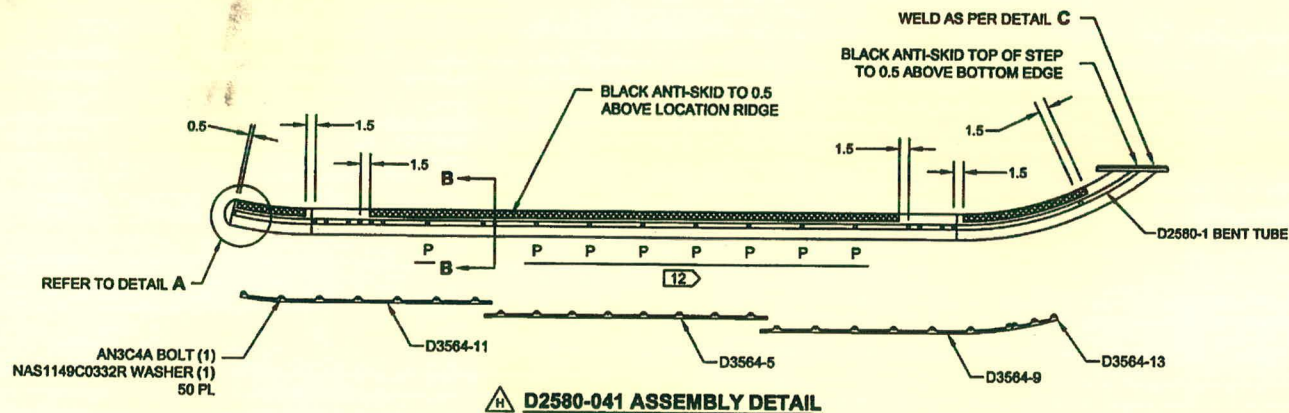
2017 JUL 05
ECN17-569

H	SHEET : PL DELETE D3568-1/-5/-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -049, -047 WEIGHT UPDATED PER DSI 9598	AJS	14.04.09
F	INCORPORATE DEO D2580-E-1 PER PAR12-218	DC	13.06.20
E	ADD D2580-047 (ZN C4-7) AND D2580-7 (ZN B3-8); INCLUDED DEO D2580-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DT8217 & DT8937 WAS TD2577-205 (ZN C4-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 6124/ 9183	PH	07.04.06
C	REDRAWN, INCLUDED DEO 9064/ 9067	CP	96.06.26
B	AS MANUFACTURED	DS	96.12.02
A	NEW ISSUE	DS	96.06.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS		
DRAWN	SAD		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	17.06.09		

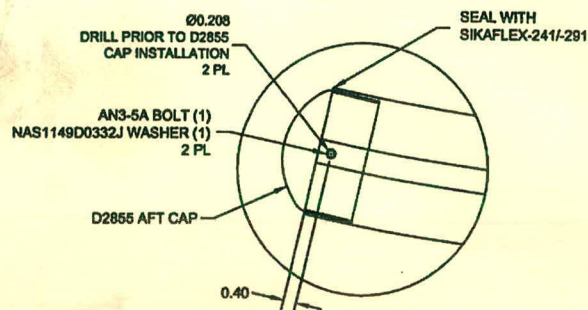
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2580
TITLE
205 SKIDTUBE ASSEMBLY
REV. H
SHEET 1 OF 9
SCALE
NTS

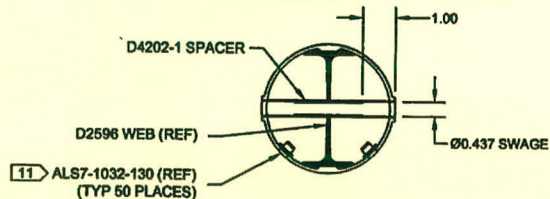
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DETAIL A
SCALE 5X



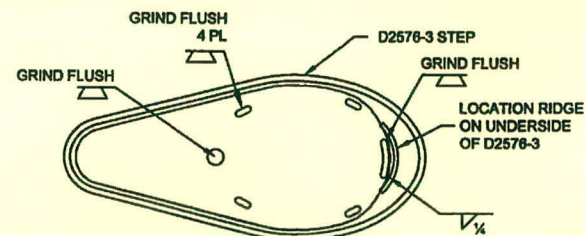
SECTION B-B
SCALE 5X



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

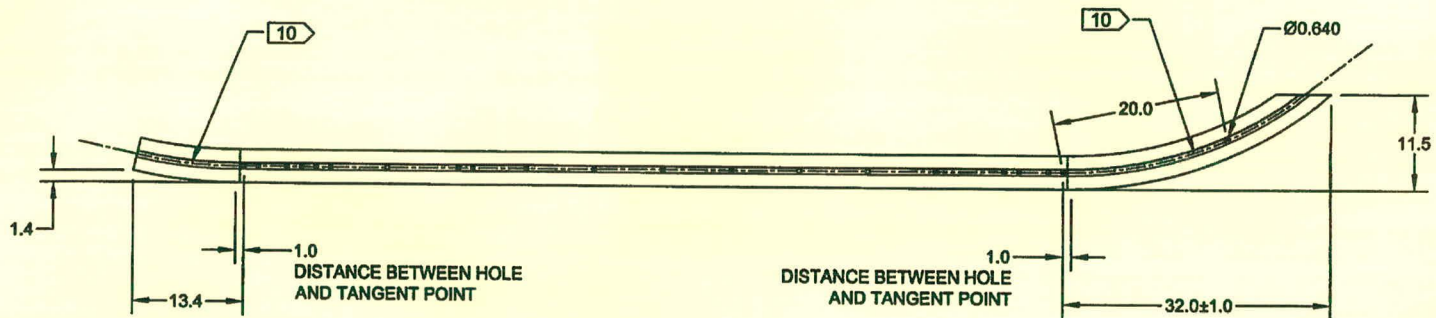
1. INSERT D4202-1 SPACER (20 PLACES)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DETAIL C
SCALE 5X



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2017 JUL 05

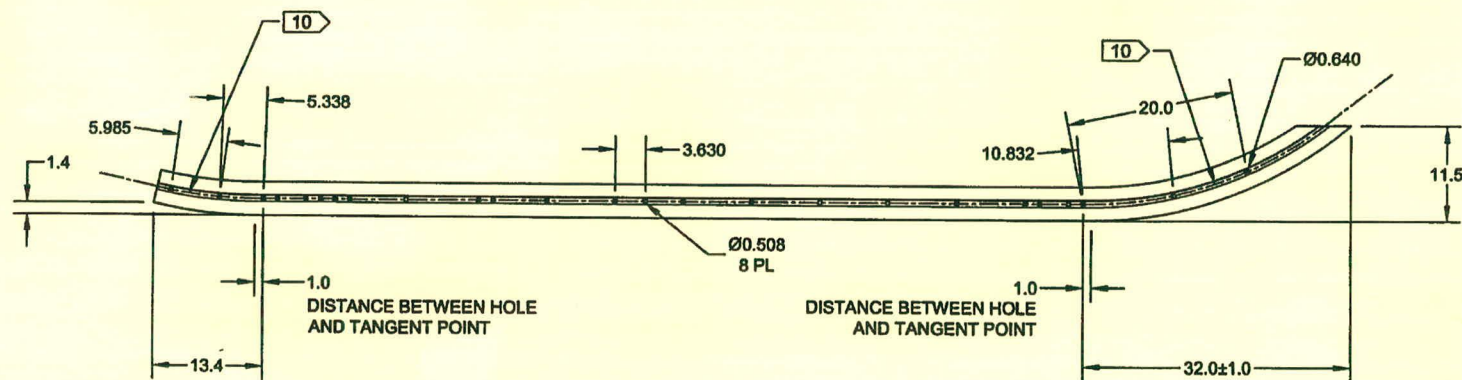
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MFG. APPR.	<i>[Signature]</i>		SHEET 2 OF 9
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D2580-1 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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D2580-7 BENT TUBE
(MAKE FROM D2580-101 TUBE)

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